Date:

Monday, 25/05/2009 12:48:34 PM

User: Julie Dawson

Process Sheet

Customer Job Number

Prsht Rev.

First Issue

Written By

Previous Run

: CU-DAR001 Dart Helicopters Services

: 48187

Estimate Number

: 10725

P.O. Number

This Issue

: 25/05/2009 S.O. No. :

: NC

: // : 47649 Type

: MACHINED PARTS

Part Number Drawing Number

: D2652 REV A

Project Number

Drawing Name

: N/A

Drawing Revision

Material Due Date

: 01/06/2009

: BUSHING

: D2652

Qty:

300 Um:

Each

Checked & Approved By

Comment

: Est Rev:B 02.06.13

Now machined in house.

NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M303R0500 1.0

303 Round Bar 0.500"

Batch: M///42

Comment: Qty.:

Total: 0.0635 f(s)/Unit Material:303 ss 500" Round Bar (M303R0500)

19.0575 f(s)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV:_ DWG REV:

2-DEBURR AS REQUIRED

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



5.0

PACKAGING RESOURCE #1



Comment: SECOND CHECK

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date:	·
	Rese	olution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			Verification Apr		Approval Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
							1.10		

NOTE: Date & initial all entries

Date: User:

Monday, 25/05/2009 12:48:34 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 48187

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



me 09-05-28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

	•								
W/O:			WC	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
- 40									
Part No		PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A :	Date: _	
	Res	solution:						Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section		Verific	Verification Approval App		
		Section A	Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48187
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

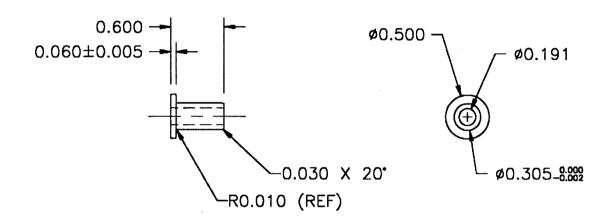
	Г			–			
		X First Arti	cle	_ Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
0.600	+/-0.010	-601					
0.060	+/-0.005	.060					
Ø0.305	-0.002/+0.000	- 30-1					
Ø0.191	+0.005/-0.000	.193		-			
Ø0.500	+/-0.010	- 500		,			
0.030 x 20°	+/-0.010	.03×26					
R0.010	+0.010/-0.000	. 500 .03×26 1.015					
leasured by:	09.05.26	Audited by:	28/07/27	F	Prototype Appro	oval:	N/A





DESIGN	DRAWN BY	•	PACE USA, INC. ATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	DIDI	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1

RELEASED PS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAXIOP COPY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISETURN TO PROTINEURING

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WORK ORDER